

Date: Thursday, 5/4/2006 1:10:03 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|---------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : INLET VALVE SHAFT |
| Job Number | : 27030 | | |
| Estimate Number | : 12249 | | |
| P.O. Number | : N/A | Part Number | : D34741 |
| This Issue | : 5/4/2006 | Drawing Number | : D3474 REV.A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A | Drawing Revision | : A |
| Previous Run | : 27023 | Material | : N/A |
| Written By | : <u>SEE COMMENT BELOW</u> | Due Date | : 5/28/2006 |
| Checked & Approved By | : <u>06/05/05</u> | Qty: | 8 |
| Comment | : est rev. 06.04.20 New issue EC | Um: | Each |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|----------------------|
| 1.0 | M303R0250 | 303 Round Bar 0.250" |
|-----|-----------|----------------------|



Comment: Qty.: 0.3171 f(s)/Unit Total : 1.2684 f(s)

AISI 303 Round Bar 0.250"

batch: M101000

06/05/17

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut blank 3.65 " long

06/05/17

8

| | | |
|-----|-------------|--------------------|
| 3.0 | LATHE CONV. | CONVENTIONAL LATHE |
|-----|-------------|--------------------|



Comment: CONVENTIONAL LATHE

1-Turn chamfer and face ends as per dwg D3474

06/05/17

8

| | | |
|-----|---------------|------------------------------|
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

1- Mill as per dwg D3474

2-Deburr as per dwg D3474

06/05/17

8

| | | |
|-----|-----|------------------------------|
| 5.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

JF. 06/05/17

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/05/19

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 1:10:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET VALVE SHAFT

Job Number: 27030

Part Number: D34741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5+441

06/05/18 (8)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/19 (8)

Job Completion



UL 06-05-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

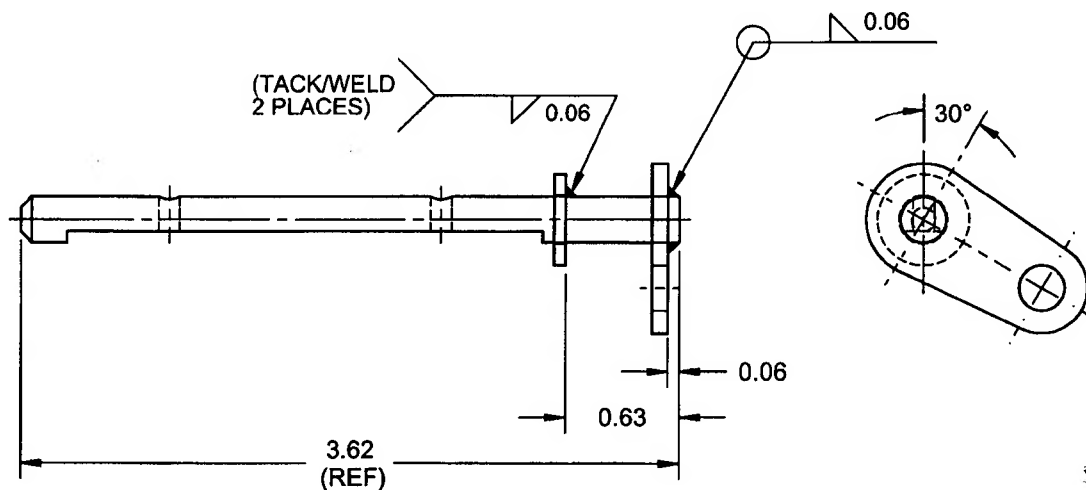
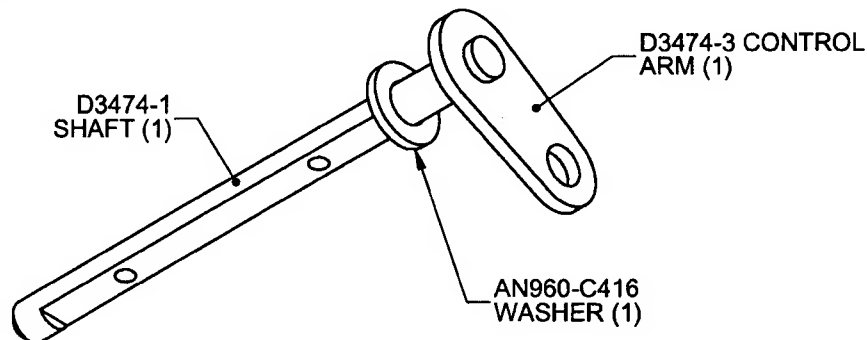
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3474 | REV. A SHEET 1 OF 4 |
| DATE 06.01.23 | | TITLE INLET VALVE SHAFT | SCALE 1:1 |
| A | 06.01.23 | NEW ISSUE | |

[Handwritten] 06.04.03**D3474-041 INLET VALVE SHAFT**

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NO. *27030*

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY -041 | P/N | DESCRIPTION |
|-------------|------------|-------------------|
| X | D3474-041 | INLET VALVE SHAFT |
| 1 | D3474-1 | SHAFT |
| 1 | D3474-3 | CONTROL ARM |
| 1 | AN960-C416 | WASHER |

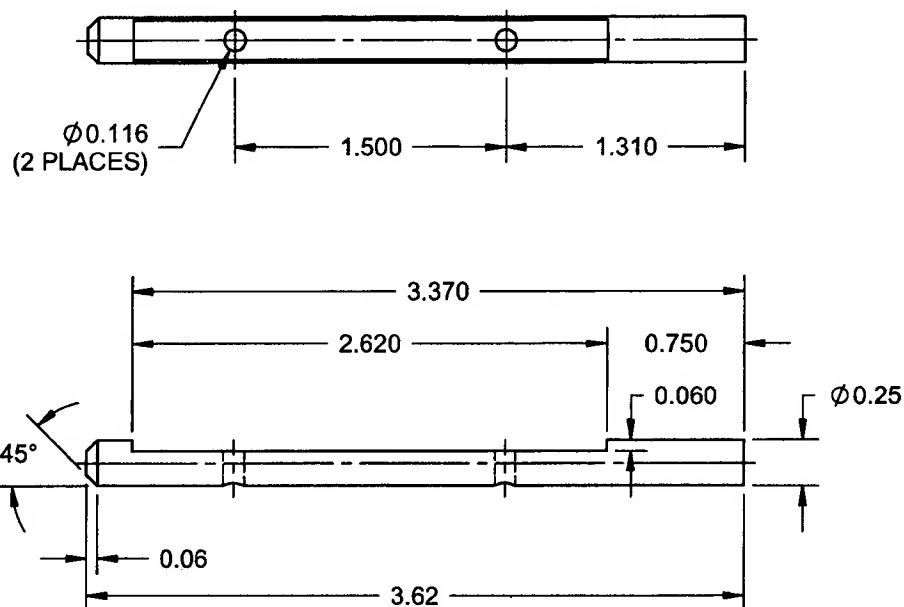
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| DATE 06.01.23 | | TITLE INLET VALVE SHAFT | SCALE 1:1 |

[Signature] 06.04.03



D3474-1 SHAFT

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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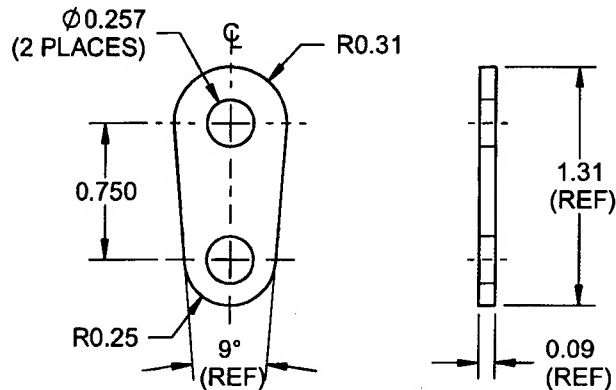
DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
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| DATE 06.01.23 | | TITLE INLET VALVE SHAFT | SCALE 1:1 |

06.04.03

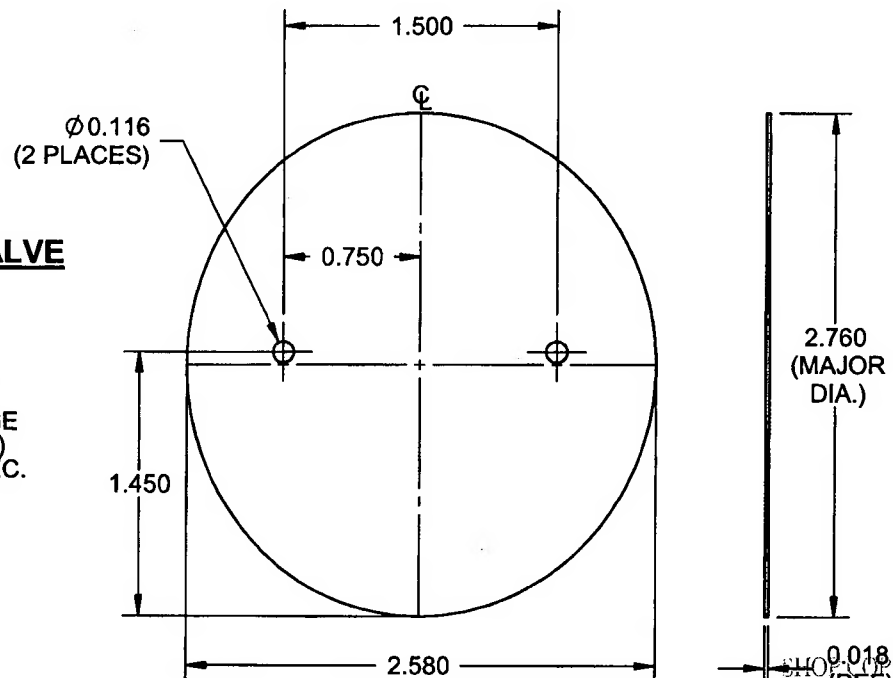
D3474-3 CONTROL ARM FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)



D3474-5 BUTTERFLY VALVE FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)



NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

0.018
(REF)
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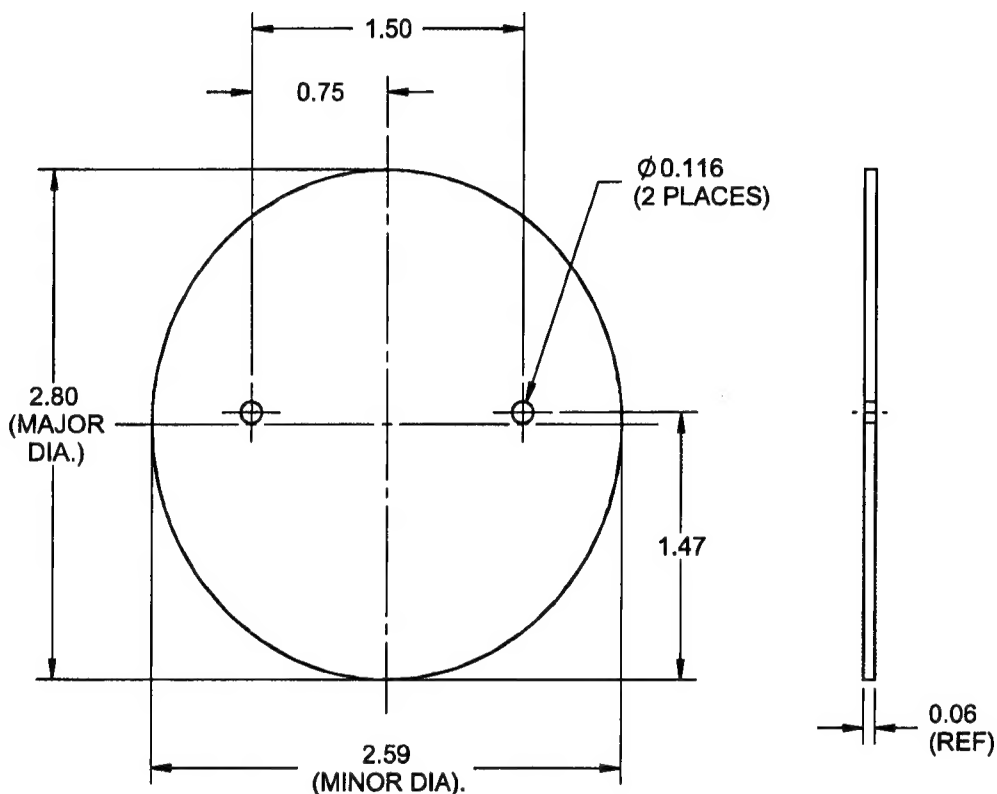
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| CHECKED # | APPROVED # | DRAWING NO. D3474 | REV. A SHEET 4 OF 4 |
| DATE 06.01.23 | | TITLE INLET VALVE SHAFT | SCALE 1:1 |

06.04.03



D3474-7 BUTTERFLY VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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